•Date:

Thursday, 14/05/2009 3:41:20 PM

User: Julie Dawson **Process Sheet Drawing Name** : LUG Customer : CU-DAR001 Dart Helicopters Services Job Number : 47967 **Estimate Number** : 11019 **Part Number** : D27313 P.O. Number : 14/05/2009 S.O. No. : **Drawing Number** : D2731 REV B This Issue : NC : N/A Prsht Rev. **Project Number** : // : B First Issue Type : MACHINED PARTS **Drawing Revision** : 43313 **Previous Run** Material Qty: : 21/05/2009 Each **Due Date** 160 Um: Written By Checked & Approved By : Est:D 00.05.19 Added inspect level 8, removed P/O for powder Comment coating EC **Additional Product** Job Number: **Machine Or Operation:** Description: Seq. #: D2423 Lug Extrusion 1.0 Comment: Qty.: 0.0717 f(s)/Unit Total: 11.4744 f(s) Lug Extrusion D2423 Batch: **24**3 2.0 BAND SAW Comment: BAND SAW Cut D2423 Extrusion: 0.82" Long 3.0 D27313P Comment: Qty.: 1.0000 Each(s)/Unit Total: 160,0000 Each(s) Lug 4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2731-3 Check for crack while loading into the machine Tumble Deburr any rough edges after tumbling INSPECT PARTS AS THEY COME OFF MACHINE 5.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Page 1

Form: rprocess

Dart Aerospac	e Lto	d
---------------	-------	---

W/O:			WC	RK ORDER CHAN	GES					
DATE	STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•								
	-	7								
Part No	:	PAR #:	Fault Cate	gory:	NC	R: Yes 1	No DQ	A:	Date:	
Resolution:										
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Sec			· · · · · · · · · · · · · · · · · · ·	Verific	ation	Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
		•						· ·		
					•					
								i		
									···	
							-	100		
	1					1	1	:		1

	hursday, 14/05/2009 3:41:20 PM Julie Dawson	Process Sheet		
	er: CU-DAR001 Dart Helicopters Se	ervices Drawing Name: LUG		
Job Numb	er: 47967	Part Number: D27313		
Job Number:				
Seq. #:	Machine Or Operation:	Description	•	
6.0	QC8	SECOND CHECK		(60)
	nment: SECOND CHECK	HAND FINIGUING DECOUDES #4	H.A O	906/06
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		18
Con	nment: HAND FINISHING RESOU Acid etch and Alodine as p		F2 09/06/0	350
8.0	POWDER COATING	POWDER COATING	100/0	> 0
	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	M11147		
Con	nment: POWDER COATING		1130111 11001 1101111111111111111111111	
	Powder Coat White Gloss	(Ref: 4.3.5.1) as per QSI 005 4.3		
	START TIME:	HODAM		
	OVEN TEMPERATURE: _ FINISH TIME: _	320°F 11:30Am	00-01-09	VIOC.
9.0	QC3	INSPECT POWDER COAT/CHÉMICAL C	ONVERSION	
		01.1		
Con 10.0	nment: INSPECT POWDER COAT PACKAGING 1	PACKAGING RESOURCE #1		50K)
				602
Con	nment: PACKAGING RESOURCE Identify and Stock	#1 / /		
	Location:	9/6/9		50
11.0	QC21	FINAL INSPECTION/W/O RÉLEASE	m m m m m m	10
Con	nment: FINAL INSPECTION/W/O	RELEASE		
Job Completion			mt 09	-06-10
				1

Form: rprocess

Page 2

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHAN	IGES		<u> </u>	-		
DATE	STEP	PRO	OCEDURE CHAN		By	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
*										
			·							
			Fault Categ	jory:	NCR: Yes No DQA: Date: _					
	Resc	olution:	Disposition	l:	QA: N/	C Clos	sed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORM	MANCE (N	ICR)				
DATE STEP		Description of NC Section A Initial Action Des						Verification Approva		
		Section A	Chief Eng	Action Description Chief Eng		ate	Secti	on C	Chief Eng	QC Inspector
				`						

DART AEROSPACE LTD	Work Order:	47967
Description: Lug	Part Number:	D2731-3
Inspection Dwg: D2731 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

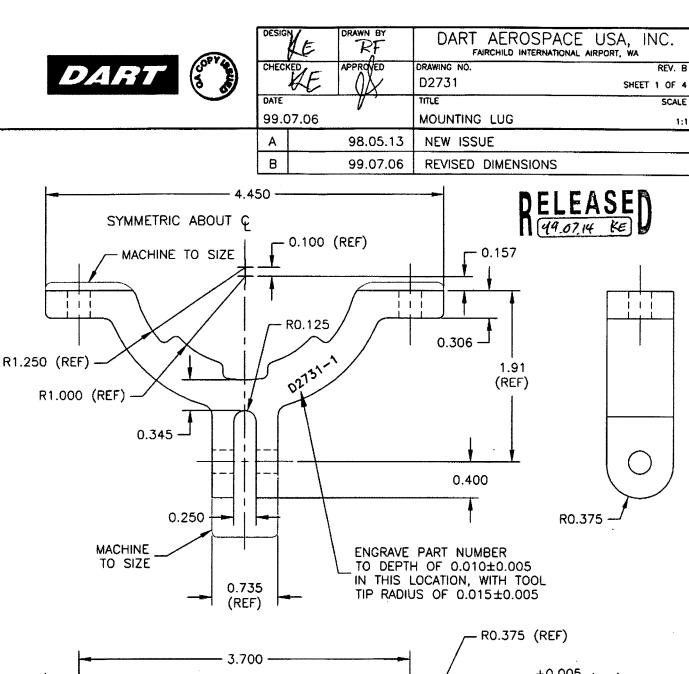
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4,451	J			
1.41	+/-0.030	J. NO	J			
0.306	+/-0.010	806.	✓ .			
0.413	+/-0.010	٤١١٦	J			
3.700	+/-0.005	3.697	✓			
0.375	+/-0.010	.376	V			
0.750	+/-0.010	.75>	✓			
Ø0.257	+0.005/-0.000		\checkmark			
0.100 X 45°	+/-0.010	100×412°	~			
			ļ			
						-
				-		

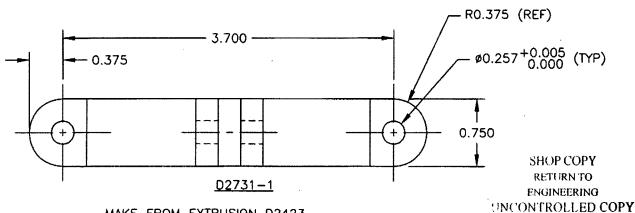
Measured by:	-tum	Audited by:	22	A	Prototype Approval:	N/A	
Date:	07/06/03	Date:	09	106/06	Date:	N/A	

Rev Da	ate Chang	e	Revised by	7.00
A 04.0	04.22 New Is	sue	KJ/RF	

Dart Aerospace Ltd

	•								
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·				1.000					
Part No	:	PAR #:	Fault Cated	jory:	_ NCR: Yes	No DQ	A:	Date:	
	Res	solution:	Disposition	ı:	_ QA: N/C CI	osed:		Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	la idi al	on B		cation	Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
·									
								1	





MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015 SUBJECT TO AMENDMENT

1:1

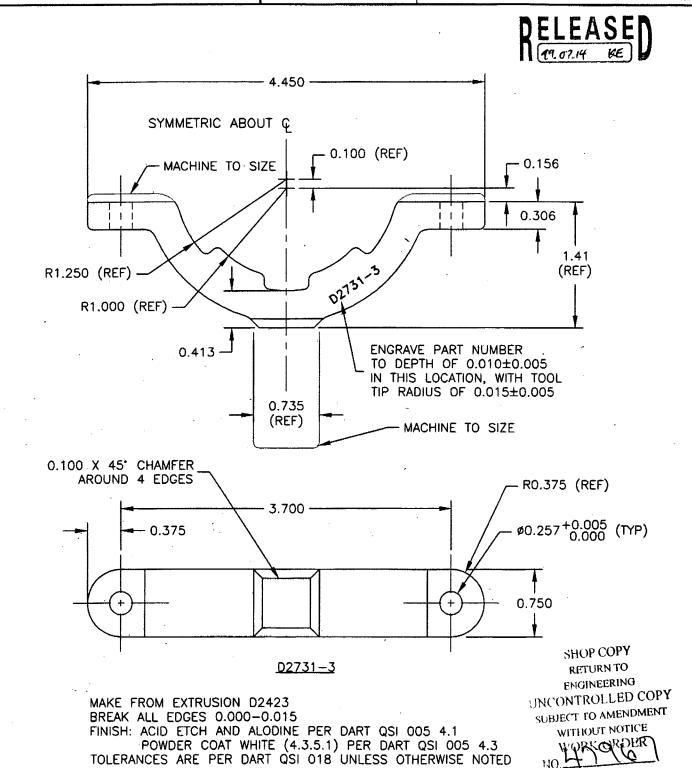
WITHOUT NOTICE FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 WORK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dar	tΑ	ero	sp	ace	L	ld
-----	----	-----	----	-----	---	----

	•									
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PR	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									•	
		,			:	-				
Part No	:	PAR #:	Fault Cate	egory:	NCR	: Yes N	lo DQ	<u> </u> \ :	Date:	
				Disposition: QA						
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC	Description of NC Corrective		on B		Verific	erification Approval		Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
		; '								
									. *	
				•						
				-						



DESIGN	DRAWN BY	DART AEROSPA FAIRCHILD INTERNAT	
CHECKED	APPROVED	DRAWING NO. D2731	REV. B
DATE	 	TITLE	SHEET 2 OF 4
99.07.06	•	MOUNTING LUG	1:1



Dart Aerospace L	ta
------------------	----

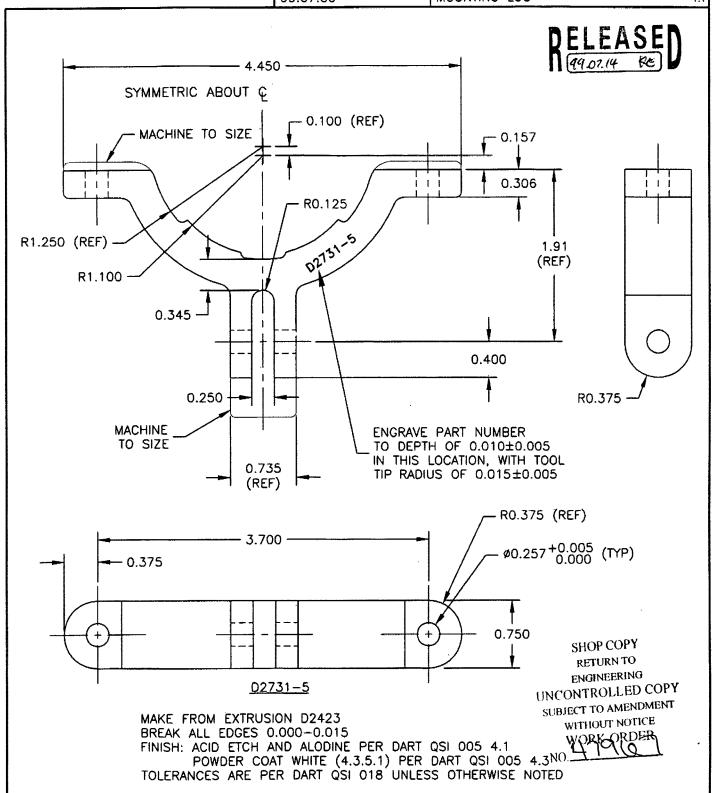
W/O:		WOR	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANG	BE B	y Da	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
					ŝ.						
Part No):	PAR #: Fault Categor	rv: NCP: \	'es No	DO 4:		Date:				

Part No: P	AR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
5475		Description of NC		Corrective Action Section B	}	Verification	Ammuoval	Annua::-!
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
				•				



DESIGN LE	DRAWN BY	DART AEROSPA	
CHECKED	APPROVED	DRAWING NO. D2731	REV. B SHEET 3 OF 4
DATE		TITLE	SCALE
99.07.06		MOUNTING LUG	1:1



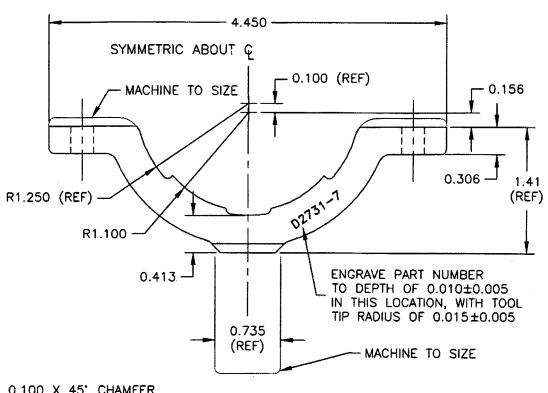
Dart Aerospace Ltd

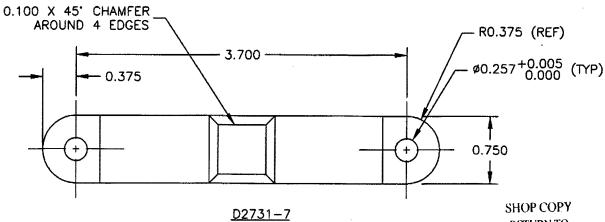
	•								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Approval Chief Eng / Prod Mgr Approv QC Inspec		
				·					
							-		
Part No:		PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	4 :	_ Date: _	
Resolution:			Disposition	on:	_ QA: N/C Cld	osed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section B			Verification		Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			Approval Chief Eng	QC Inspector
				•					
						,		:	
•									
									
						1		1	



DESIGN	DRAWN BY	DART AEROSPA FAIRCHILD INTERNATION	
CHECKED	APPROVED	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE	<u> </u>	TITLE	SCALE
99.07.06		MOUNTING LUG	1:1

RELEASED





MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO.L

Dart Aerospac	e L	td
---------------	-----	----

W/O:	•		WC	ORK ORDER CHANG	GES						
DATE	STEP	PR	OCEDURE CHA	•	By Date Qty Chief Eng Prod Mg					Approval QC Inspector	
									Prod Wigi	·	
				•							
Part No:		PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ/	4 :	Date:		
				Disposition: QA: N/C Closed: D							
NCR:				ER NON-CONFORM							
DATE	CTED	Description of NC		Corrective Action Sec	ction B		Verific	ation	Approval	Annroyal	
DATE	STEP	Section A	Initial Chief Eng			ign & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector	
									•		
		}									
		,						•			
								:			
· 											
										-	